

Work Order ID 153800

Friday, November 25, 2016 7:43:18 AM

153800

Page 1

Item ID: D4276-1

Revision ID:

Item Name: Aft Beam

Start Date: 11/30/2016 Start Qty: 2.00

Required Date: 12/6/2016 Req'd Qty: 2.00

Reference:

Accept

N900040100Setup Start ***NS1***Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

DAS
21
9-89

Date: NOV 29 2016

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4276

A

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

Memo

Cut Blank to 36.630"

Batch: 125861

0.00

0.03

3 0 1612-17

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

Memo

1-Machine per folio FB007

DWG REV: AA

FOLIO REV: A

0.00

0.21

3 0 1612-18

2- deburr rough edges

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Friday, November 25, 2016 7:43:18 AM

Page 2

[illegible]

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Work Order ID 153800

Friday, November 25, 2016 7:43:18 AM

153800

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Item ID: D4276-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Aft Beam
 Start Date: 11/30/2016 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/6/2016 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
145 *145* Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M1166113.</i> Memo MASK AS PER DWG	0.00 0.05	<i>START: 2:35. O.V. T: 3:00 FINISH: 3:05.</i>			<i>3</i>	<i>0</i>	<i>16-12-22</i>	<i>9-89</i>
150 *150* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				<i>3</i>	<i>16-12-23</i>		DAS <i>9</i> 9-89
180 *180* Packaging Packaging	Identify as per dwg & Stock Location: <i>51463</i> Memo	0.00 0.00						JAN 0 6 2017	DAS <i>6</i> 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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153800

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N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Start Date: 11/30/2016 **Start Qty:** 2.00 ***2***

Required Date: 12/6/2016 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

**Insp.
Stamp**

0.00

190

QC

Memo

0.03

Quality Control

DAS
21
9-89

JAN 06 2017

JAN 06 2017

DQA: _____ Date: _____



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Picklist Print

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Page 1

Work Order ID: 153800

153800

Parent Item: D4276-1

D4276-1

Parent Item Name: Aft Beam

Start Date: 11/30/2016

Required Date: 12/6/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-11-17 JLM VERIFIED BY:DD IPP rev:B
10.12.02 AS PER DWG REV.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.000X04.00 0		Purchased		No		100	f	21.1555	3.052	6.425263			

M6061T6B1 000X04 000

6061-T6 Bar 1.00 x 4.00

SL 16-12-17

Location

Loc Qty

Loc Code

MAT003

21.1555

M129167

3.6

M134553

1.5055

M134776

2

M135559

2.05

M135861

12

9.2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

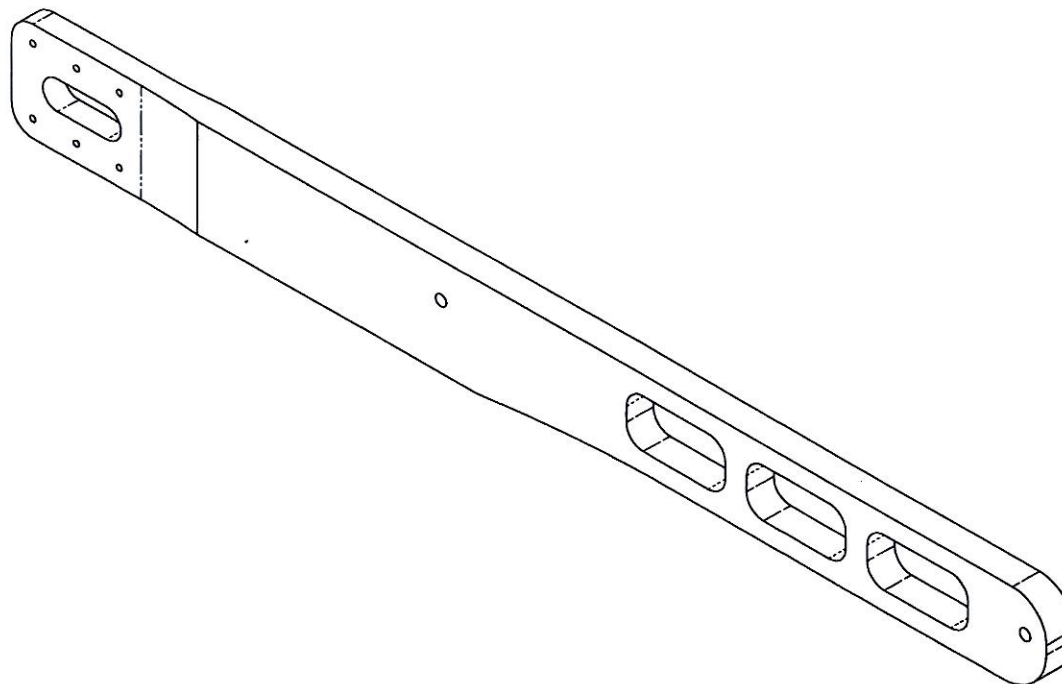
DART AEROSPACE LTD		Work Order:	153800
Description: Aft Beam		Part Number:	D4276-1
Inspection Dwg: D4276 Rev: A		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.75	+/-0.030	.750	/		VERO	LTD
20.500	+/-0.010	20.500	/			
Ø0.381	+0.000/-0.001	.381	/		g-PIN	
14.380	+/-0.010	14.380	/			
R0.75	+/-0.030	R.750	/			
3.50	+/-0.030	3.499	/			
16.38	+/-0.030	16.380	/			
5.00	+/-0.030	4.997	/			
0.75	+/-0.030	.747	/			
2.75	+/-0.030	2.745	/			
3.00	+/-0.030	2.999	/			
1.250	+/-0.010	1.250	/			
4.50	+/-0.030	4.500	/			
0.734	+/-0.010	.737	/			
0.108	+/-0.010	.107	/			
36.38	+/-0.030	36.38	/		IND. TAPE	
0.95	+/-0.030	.945	/			
0.60	+/-0.030	.605	/			
2.70	+/-0.030	2.700	/			
1.10	+/-0.030	1.10	/			
1.25	+/-0.030	1.254	/			
0.75	+/-0.030	.754	/			
3.000	+/-0.010	3.000	/			
1.500	+/-0.010	1.500	/			
Ø0.191	+0.005/-0.001	.194	/			
2.300	+/-0.010	2.300	/			
3.50	+/-0.030	3.501	/			
R0.60	+/-0.030	R.60	/			
1.70	+/-0.030	1.702	/			
0.65	+/-0.030	.647	/			

Measured by:	SK	Audited by:	AS	Preliminary Approval:	
Date:	16-12-18	Date:	16-12-18	Date:	

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ	



D4276-1 AFT BEAM

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 153800 MJS
16-11-29

RELEASE
2010-11-30
JPH

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 8.68 lbs
- 8) MASK HOLES PRIOR TO POWDER COAT.

A		NEW ISSUE		SC	10.11.25
REV.		DESCRIPTION		BY	DATE
DESIGN		SC		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN		JPH			
CHECKED		#		DRAWING NO.	REV. A
MFG. APPR.		#		D4276	SHEET 1 OF 2
APPROVED		#		TITLE	SCALE
DE APPR.		#		AFT BEAM	NTS
DATE	10.11.25	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD			

